

**Work Order ID 59281**

Friday, May 28, 2010 2:25:29 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 5/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 10-5-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

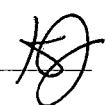
DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG002

N/A 

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

M 10/5/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

1 - - AWM 10-5-31

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 0 BE 10/05/31

W/O:		WORK ORDER CHANGES					
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Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

M112860

BE 10/05/31

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

M112860

BE 10/05/31

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

BE 10/04/01

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

M 10/5 / 1

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

W/O:		WORK ORDER CHANGES					
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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

S. 106661

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S. 106661

Quality Control

④

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

① H 10-6-1

W/O:		WORK ORDER CHANGES					
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Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

=) M 10/06/01



11114207

Powdercoat

Memo

0.00

Powder Coating

START TIME:

7:30 AM

OVEN TEMPERATURE:

320°C

FINISH TIME:

8:00 AM

1 2

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 BL 10.6.2

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts &amp; wearplates &amp; Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 113435 ☐

Sikaflex expire date: 10/11

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as  
per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with  
Sikaflex. Clean excess adhesiveA/R ☐ ☐ ☐ Sikaflex-291 ☐ 114135 ☐

Sikaflex expire date: 10/11

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 114132

① BR 10-6-2.

W/O:		WORK ORDER CHANGES					
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Required Date: 6/4/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00

S 10/06/03



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

PPD 58495

10/06/03 ④

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/04 J

MF  
10-6-3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 1

Work Order ID: 59281

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD  
 IPP Rev. O 06.02.28 Added paperwork EC  
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 5/28/2010

Required Date: 6/4/2010

Start Qty: 1.00

Required Qty: 1.00

D2580-1 Manufactured No 110 Each 15.0000 1 1  
 205 Skidtube bent detail

Location	Loc Qty	Loc Code
LG	9	
57028	1	
58384	1	
58385	1	
58618	2	
58619	2	
59143	2	
ST046	6	
58747	2	
58748	2	
59030	2	

D2576-3 Manufactured No 140 Each 99.0000 1 1  
 Step (maching detail)

Location	Loc Qty	Loc Code
LG	99	
46661	51	
52215	48	

D2579 Manufactured No 140 Each 224.0000 20 20  
 Crossbolt Spacer

Location	Loc Qty	Loc Code
LG	224	
57052	5	
57348	8	
58433	211	

1 10/5/31  
 1 BE 10/05/31  
 20 20 BE 10/05/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 5/28/2010

Required Date: 6/4/2010

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200 Each

96.0000

1

1



Cap

Location

Loc Qty

Loc Code

FP6

2

56613

2

ST026

94

50513

1

50770

28

51539 ✓

12

53791

53

1 Bk 10-6-2

AN3-5A

Purchased

No

200

Each

847.0000

2

2



Bolt

Location

Loc Qty

Loc Code

ST350

847

105057 ✓

847

2 Bk 10-6-2

AN960JD10L

NAS1149D0332J

Purchased

No

200

Each

3,923.000

2

2



Washer

Location

Loc Qty

Loc Code

ST348

3923

110985 ✓

3923

2 Bk 10-6-2

ALS7-1032-130

Purchased

No

200

Each

17.0000

50

50



Insert

Location

Loc Qty

Loc Code

ST282

17

113238

17

50 Bk 10-6-2

Friday, May 28, 2010 2:25:34 PM

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Page 2

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Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 929.0000 50 50



BOLT



Location	Loc Qty	Loc Code
ST350	929	
114103	501	
114108	300	
114416	12	
114523	116	

AN960C10L NAS1149C0332 Purchased No 200 Each 0.0000 50 50



washer

D3566-13



Gasket

NAS 1149C0332R

114341



36 BK 10-6-2  
 14 BK 10-6-2  
 50 BK 10-6-2

Manufactured No 200 Each 24.0000 1 1



Location	Loc Qty	Loc Code
FP	24	
53461	24	

D3566-5 Manufactured No 200 Each 12.0000 1 1



Gasket

Location	Loc Qty	Loc Code
FP015	12	
57682	12	

1 BK 10-6-2  
 1 BK 10-6-2

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Start Qty: 1.00

Required Qty: 1.00

D3566-1	Manufactured	No	200	Each	23.0000	2	2
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP015	23	
57715 ✓	2	
58182 ✓	21	

2 BR 10-6-2  
1

D3564-11	Manufactured	No	200	Each	11.0000	1	
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP019	11	
59021 ✓	11	

1 BR 10-6-2  
1

D3564-13	Manufactured	No	200	Each	18.0000	1	
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP17	18	
57684 ✓	4	
57922	14	

1 BR 10-6-2

D3564-9	Manufactured	No	200	Each	13.0000	1	1
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	1	
55334	1	
FP019	12	
57958 ✓	12	

1 BR 10-6-2

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Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No 200 Each 20.0000 1 1  
 Wearshoe

Location	Loc Qty	Loc Code
FG	1	
34806	1	
FP19	19	
57525	1	
58709 ✓	18	

D2594-3 Manufactured No 200 Each 263.0000 16 16  
 O-Ring, 205 Skidtube

Location	Loc Qty	Loc Code
FP	263	
55546 ✓	19	
58191 ✓	244	

D2594-1 Manufactured No 200 Each 438.0000 16 16  
 Plug, 205 Skidtube

Location	Loc Qty	Loc Code
FP	302	
42807	112	
55002 ✓	71	
57826 ✓	119	
FP14	136	
58434	136	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07.06.28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59287

*BS 10-528*

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RELEASED  
07-06-28

Diagram illustrating the grinding locations on a propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular component with a central hole and a rectangular slot. The drawing includes dimension lines and labels for various parts and materials:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to the central hole.
- SEAL WITH SIKAFLEX-241/-291**: Points to the outer edge of the component.
- AN3-5A BOLT (1)**: Points to the bolt passing through the central hole.
- AN960/D10L WASHER (1)**: Points to the washer under the bolt.
- (2 PLACES)**: Points to the two locations where the cap is installed.
- D2855 CAP**: Points to the cap installed on the component.
- 0.40**: Dimension line indicating the width of the rectangular slot.

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50  
DISTANCE TO AFT END  
OF D2596 WEB

3  
7

1.750 1.750

0.508 (TYP.)  
(40 PLACES)

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)  
7 EQUAL SPACES  
8.188 PITCH

38.0

91.500

190.0  
(D2500-1)

REFER TO DETAIL A

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 D

8

1.5 1.5 1.5

P P P P P P P

REFER TO DETAIL C

D3566-1 D3566-5 D3566-13

D3564-11 D3564-5 D3564-9 D3564-13

AN304A BOLT (1)  
AN960C10L WASHER (1)  
(50 PLACES)

DESIGN	1	DRAWN BY	
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07.02.27

**DART AEROSPACE LTD.**  
HAMPSHIRE, ONTARIO, CANADA

205 SKIDTUBE ASSEMBLY

1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RELEASED  
07 Dec 78

Diagram illustrating the grinding locations for the propeller cross-section. The diagram shows a cross-section of a propeller with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a bolted joint assembly. The drawing shows a cross-section of a bolted joint. The components and dimensions are labeled as follows:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to the two locations where a hole must be drilled in the upper plate.
- #0.208**: Dimension indicating the diameter of the hole to be drilled.
- SEAL WITH SIKAFLEX-241/-291**: Points to the sealant applied to the joint.
- AN3-SA BOLT (1)**: Points to the bolt used to secure the joint.
- AN960JD10L WASHER (1)**: Points to the washer used under the bolt head.
- D2855 CAP**: Points to the cap used to secure the joint.
- SEE NOTE ii)**: Points to the joint area.
- 0.40**: Dimension indicating the thickness of the upper plate.

D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)  
(TYP 50 PLACES)

AFTER PERFORM

1. CHA
2. INS
3. WEI
4. C'B

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

37.50  
DISTANCE TO AFT END  
OF D2596 WEB

3  
7

1.750 1.750

0.0508 (TYP.)  
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF.)  
7 EQUAL SPACES  
8.188 PITCH

38.0

91.500

190.0  
(D2500-1)

Technical drawing of a propeller shaft. The shaft is shown in profile, with a central section labeled "51.340". Dimensions from the left end include 5.985, 1.4, 5.338 (REF), 3.630 (REF), 5.915, and 39.580. A callout "4" points to the left end. The shaft has a diameter of  $\phi 0.508$  (8 PLACES). The right end has a diameter of  $\phi 0.640$  and a 20.0 degree angle. A dimension of 11.0 is shown at the right end. The distance between the hole and the tangent point is 1.0. The total length is 32.0  $\pm$  1.0. A callout "4" points to the right end.

[illegible]

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07.02.27

205 SKI

ASSEMBLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

NO. 232

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 58508  
Part number: D205 634 041  
Description: 205 tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier P. J. P. P. Date of Test Coupon 10.05.18  
Welder Barclay Elliott Date of Test Coupon 10.05.18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld